

FIG. 1

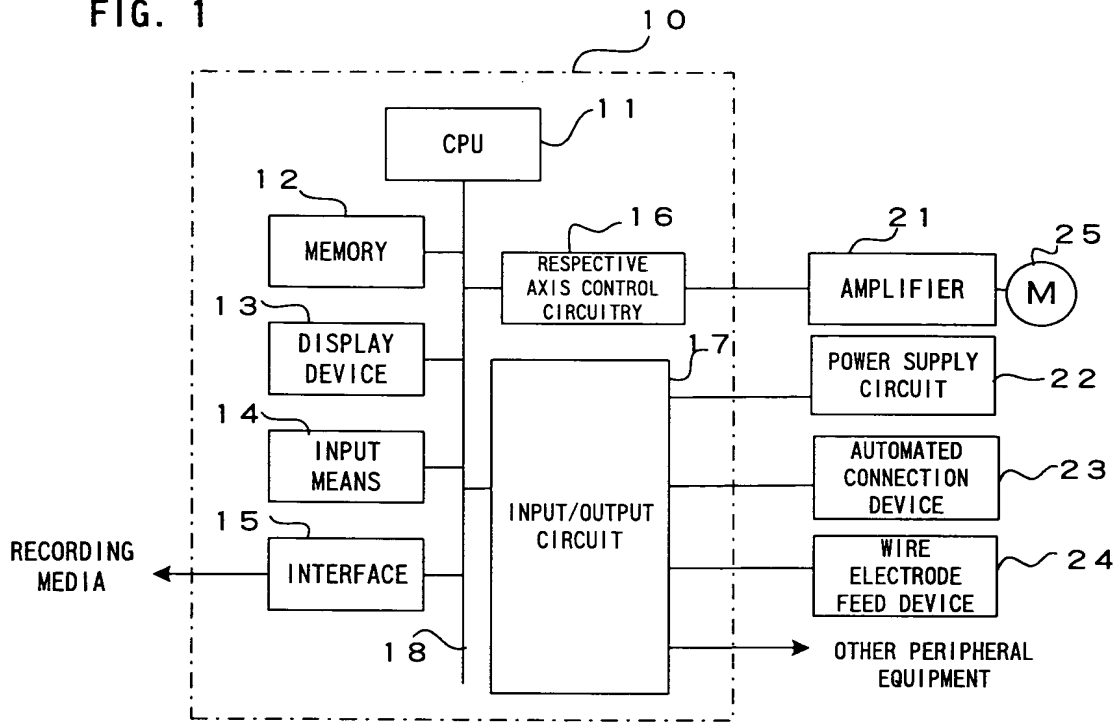


FIG. 2

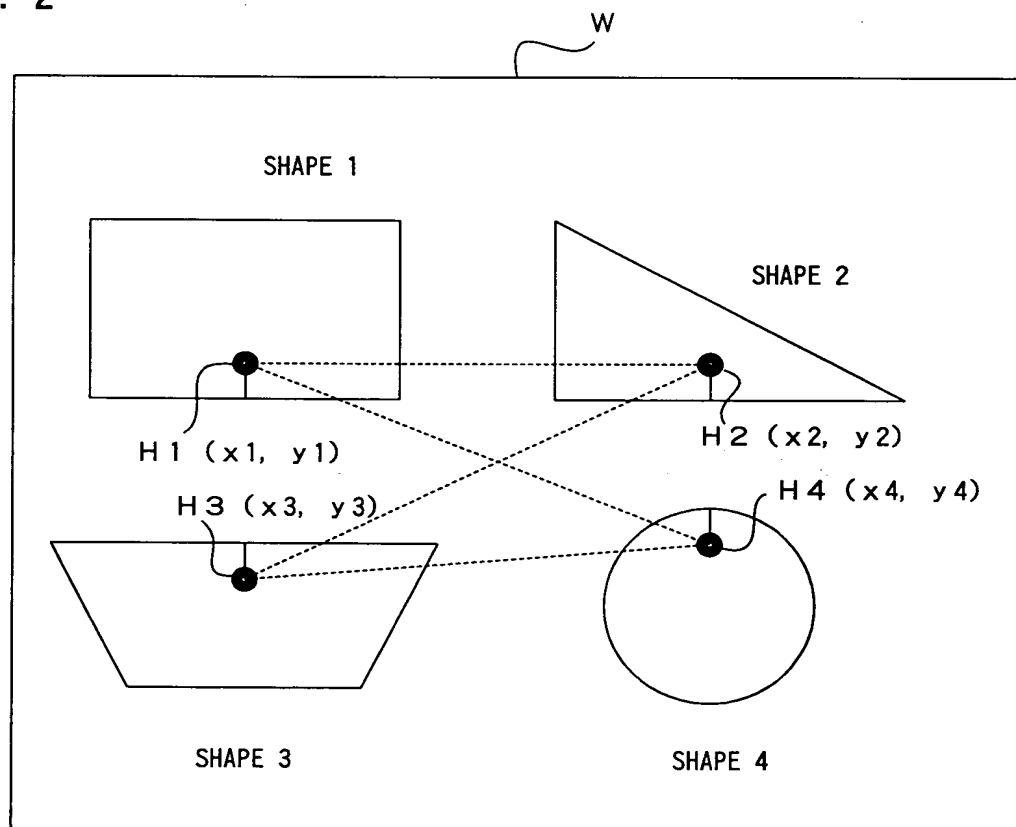


FIG. 3

	ROUGHING	FINISH MACHINING
SHAPE 1	CONNECTION 1	CONNECTION 5
SHAPE 2	CONNECTION 2	CONNECTION 6
SHAPE 3	CONNECTION 3	CONNECTION 7
SHAPE 4	CONNECTION 4	CONNECTION 8

FIG. 4

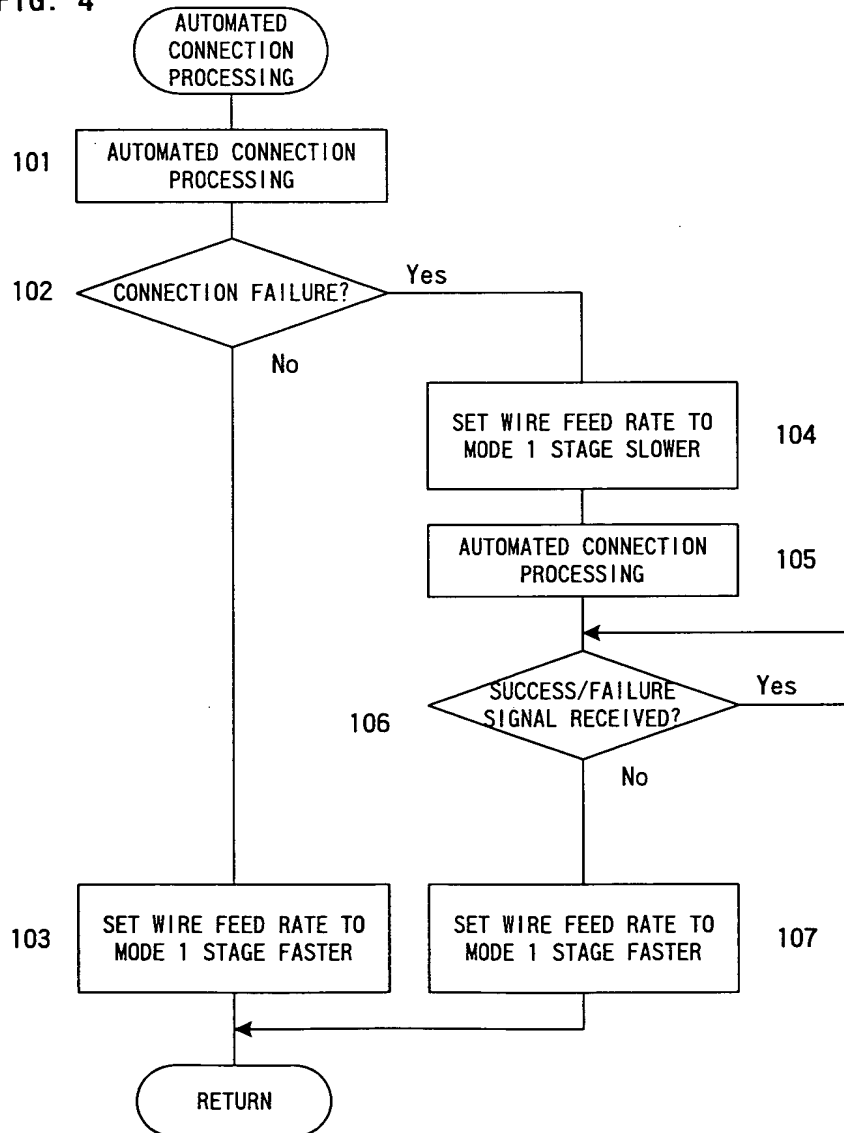


FIG. 5

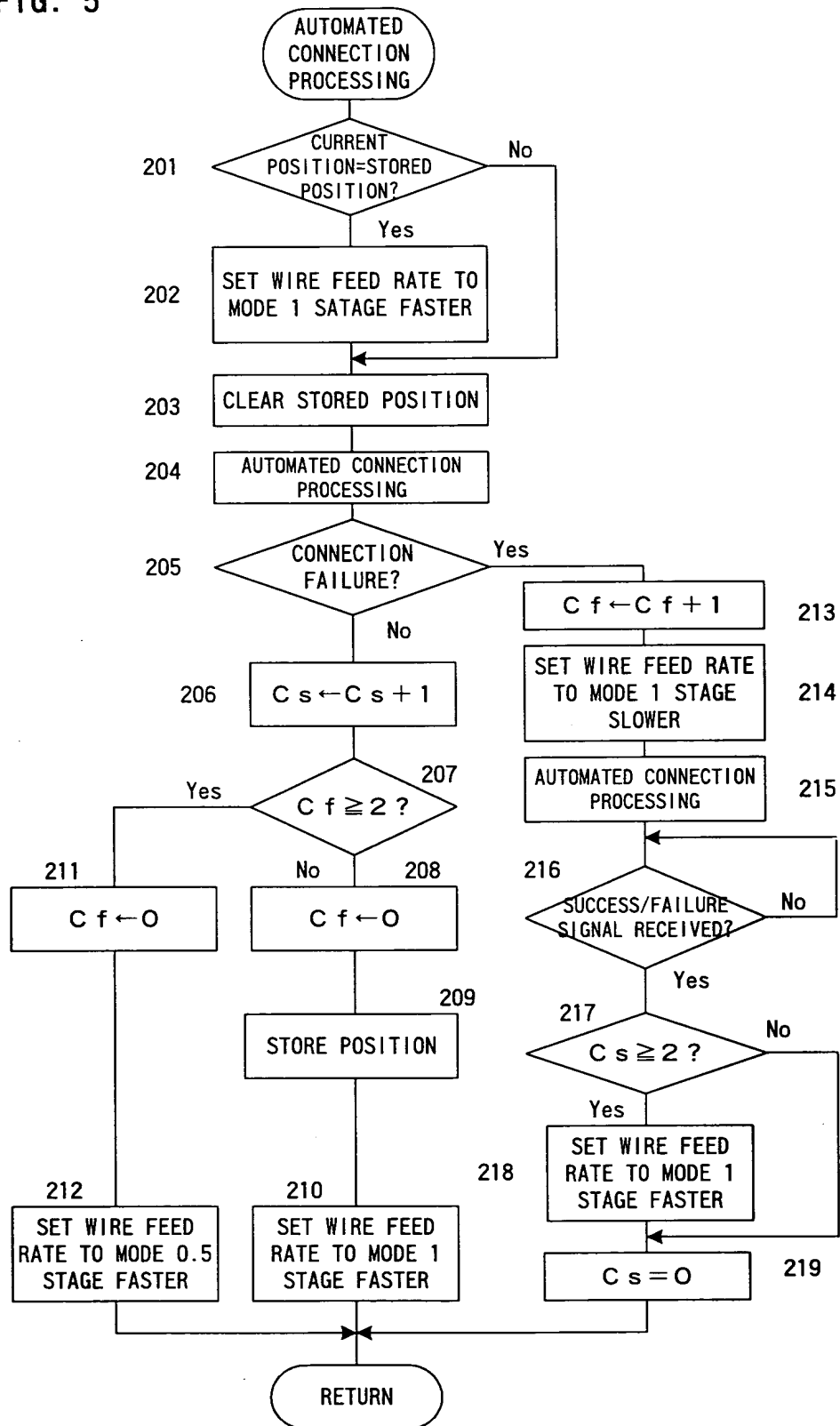


FIG. 6

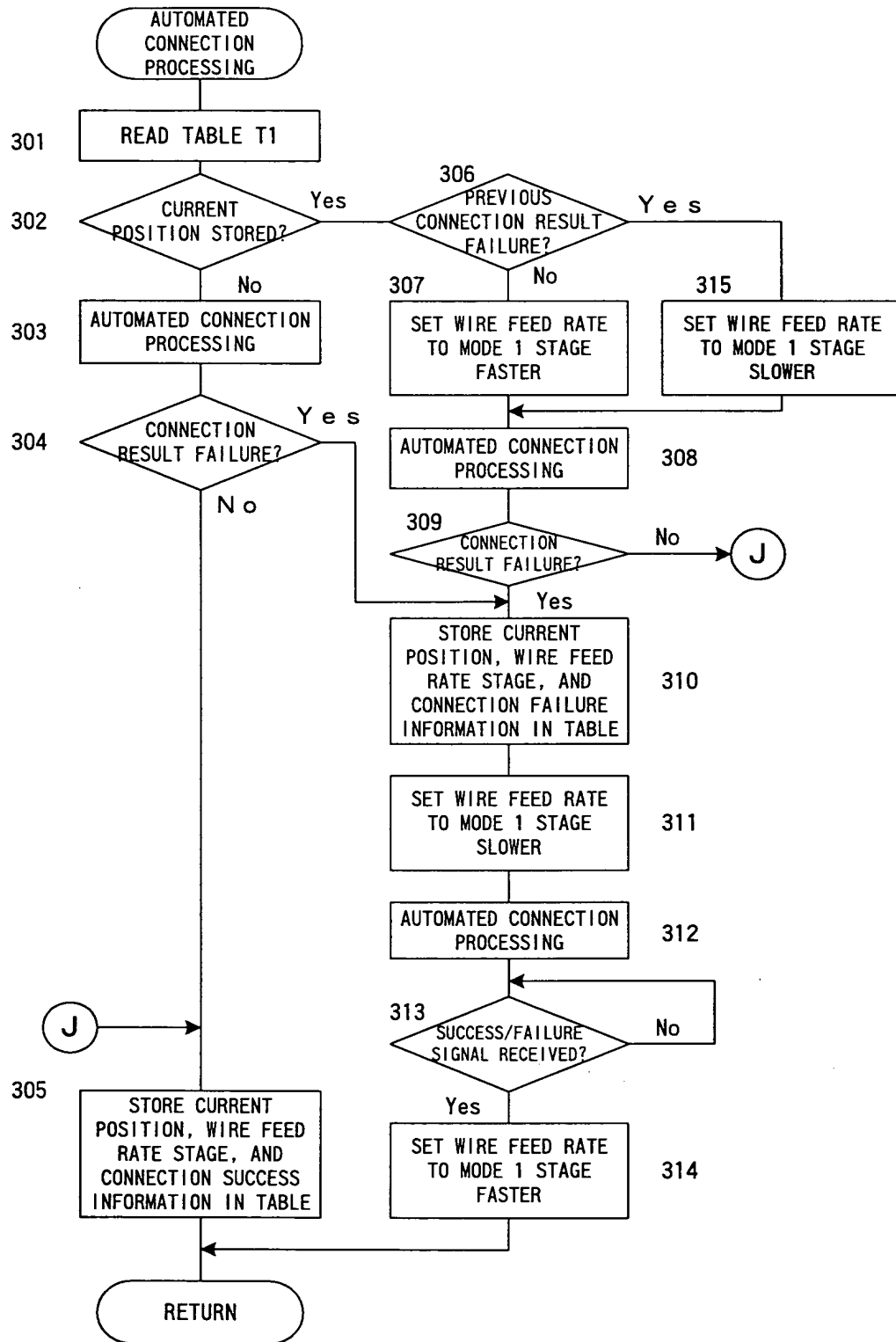


FIG. 7

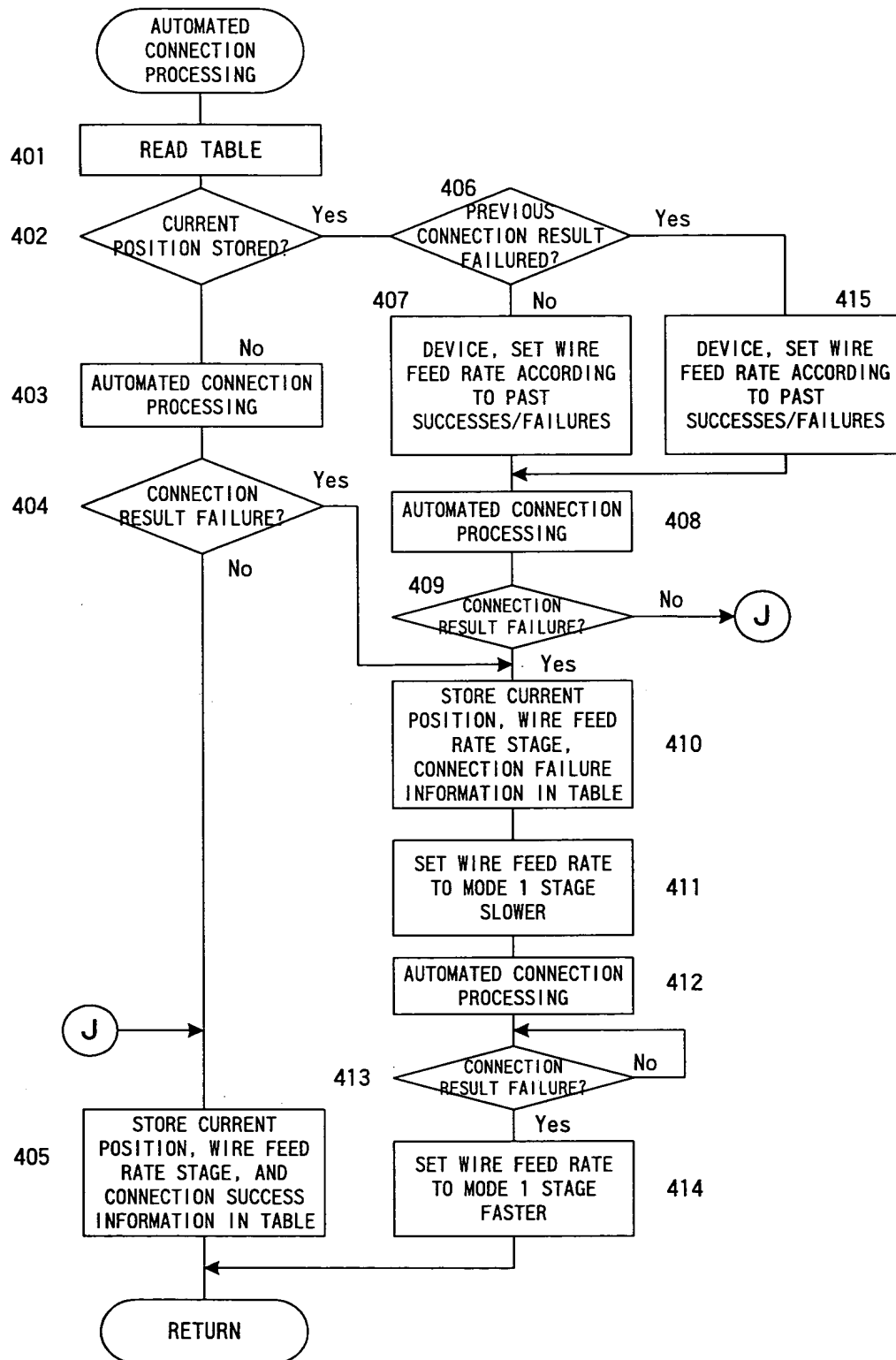


FIG. 8

T 1

THROUGH-HOLE POSITION	WIRE FEED RATE STAGE	SUCCESS(0)/FAILURE(1)
(x 1, y 1)	0	0
(x 2, y 2)	0	0
(x 3, y 3)	0	0
(x 4, y 4)	0	0

FIG. 9

T 2

THROUGH-HOLE POSITION	WIRE FEED RATE STAGE	SUCCESS(0)/FAILURE(1)		
(x 1, y 1)	0	0	0	0
(x 2, y 2)	0	0	0	0
(x 3, y 3)	0	0	0	0
(x 4, y 4)	0	0	0	0